

Amendments to the Claims:

Claims 1-18. (canceled)

19. (currently amended) A rivet comprising:
a shank having a head at one end thereof; and
wherein said shank and said head consist essentially of one of the group consisting of aluminum, an aluminum alloy, titanium, and a titanium alloy, and wherein said shank and said head substantially comprise a grain structure having a grain size less than about 5 microns.

20. (canceled)

21. (original) A rivet according to Claim 19 wherein the end of said shank opposite said head is adapted to be upset to form a second head.

Claims 22-29. (canceled)

30. (previously presented) A rivet according to Claim 19 wherein said shank and said head comprise a grain structure having a grain size between 3 microns and 5 microns.

31. (previously presented) A rivet according to Claim 19 wherein said shank and said head comprise a refined grain structure formed by stirring with a friction stir welding probe.

32. (canceled)

33. (previously presented) A rivet according to Claim 19 wherein said shank and said head comprise aluminum.

34. (previously presented) A rivet according to Claim 19 wherein said shank and said head comprise AA 2195-T6 aluminum alloy.

35. (new) A rivet according to Claim 19 wherein said shank and said head consist essentially of a series 2000 aluminum alloy.

36. (new) A rivet according to Claim 19 wherein said shank and said head consist essentially of AA 2195-T6 aluminum alloy.

37. (new) A rivet according to Claim 19 wherein said shank and said head consist essentially of AA 2017-T4 aluminum alloy.

38. (new) A rivet comprising:
a shank having a head at one end thereof; and
wherein said shank and said head consist essentially of a grain structure having a grain size between about 3 microns and 5 microns.

39. (new) A rivet according to Claim 38 wherein said shank and said head comprise a material selected from the group consisting of aluminum, an aluminum alloy, titanium, and a titanium alloy.

40. (new) A rivet according to Claim 38 wherein the end of said shank opposite said head is adapted to be upset to form a second head.

41. (new) A rivet according to Claim 38 wherein said shank and said head comprise a refined grain structure formed by stirring with a friction stir welding probe.

42. (new) A rivet according to Claim 38 wherein said shank and said head comprise aluminum.

43. (new) A rivet according to Claim 38 wherein said shank and said head comprise AA 2195-T6 aluminum alloy.

44. (new) A rivet according to Claim 38 wherein said shank and said head consist essentially of a series 2000 aluminum alloy.

45. (new) A rivet according to Claim 38 wherein said shank and said head consist essentially of AA 2195-T6 aluminum alloy.

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46. (new) A rivet according to Claim 38 wherein said shank and said head consist essentially of AA 2017-T4 aluminum alloy.